

5/45

2434

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| DART AEROSPACE LTD. | Work Order: | 24434 |
| Description: Saddle Fitting, Aft (Outboard/Inboard) | Part Number: | D2573/D2574 |
| Drawing: D2573 Rev. D/D2574 Rev. D | Qty: | 8 |
| | | Page 1 of 1 |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----------|----------|-----|
| 1 | DC | Issue Traveller Dwg not required | MF | 05.10.12 | 8 |
| 2 | MV | Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No. B24893 | MS | 06/01/12 | |
| 3 | MV | Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B21801 | MS | 06/01/12 | 8 |
| 4 | MV | Fixturing W/O No. <u> </u> Fixturing Inspection last completed <u> </u> by <u> </u> | | N/A | |
| 5 | MV | Program Batch No. <u>B24434</u> Double check by: <u> </u> | MS | 06/01/12 | 8 |
| 6 | MV | Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets | SG MS | 06/01/12 | 8 |
| 7 | MV | Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets | SG MS | 06/01/12 | 8 |
| 8 | MV | Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets | SG MS | 06/01/12 | 8 |
| 9 | MV | Machine keyway as per dwg D2573 & D2574 | SG MS | 06/01/16 | 8 |
| 10 | MV | Deburr and remove all machining marks | SG | 06/01/16 | 8 |
| 11 | MV | Tumble for 20 minutes to remove sharp edges <u> </u> #04.06.21 | N/A SG | 06/01/20 | 8 |
| 12 | QC1 | Inspect all dimensions to dimension sheets | SG | 06/01/19 | 8 |
| 13 | QC7 | Second inspection | SG | 06.01.20 | 8 |
| 14 | FP | Acid etch and alodine as per QSI 005 4.1 | SG | 06.01.21 | 8 |
| 15 | FP | Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3 | SG | 06 01 31 | 8 |
| 16 | QC3 | Inspect Powder Coat | CL | 06/01/31 | 8 |
| 17 | ST | Identify and Stock. | CL | 06/01/31 | 8 |
| 18 | AC | Cost / Part | SG | 06.02.01 | 8 |
| 19 | DC | Close W/O Inspection Level 21 | SG | 06/02/11 | 8 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|--|------------|----------|
| D | 99.09.09 | Added inspection level, Qty column | EC | |
| E | 00.07.04 | Removed P/O for powder coat, drawing change rev. C | EC | |
| F | 00.07.20 | Removed inspection level 7 | EC | |
| G | 01.04.27 | Added D6101-007 & step 8 | EC | |
| H | 02.10.02 | Re-format; Change to Dwg Rev. D & incorporated D2574 | KJ | |

RELEASED
02/10/15